

Work Order ID 48674

July 2, 2009 3:05:14 PM



Page 1

Item ID: D3789-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

000

0.00



PURCHASING

Purchasing

Memo

0.00

28 09/07/21

Purchasing

Send Blanks To: Metec/Mast Precision

HAAS

Machining I/P/O:

Machine D3789-3 as per Dwg D3789

MACHINE AS PER FOLD.

Folio Rev: AA

Day Rev: A

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

28 09/07/21

Packaging

QC2

120

QC6 Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

28 09/07/13

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Page 2

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Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

09-07-14

0.00

15

BK

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

09-07-14

0.00

15

JK

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

*****Mask bearing bore prior to powder coat*****

TIME: 9:15am COVEN TEMPERATURE:

9:45am FINISH TIME: 3200F

M112148

START

15

JK

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



BR 09-07-14 (15)

QC

Memo

0.00

Quality Control

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- press fit D2611 bearing after powder coat 12- stake D2611 bearing 4 places each side as per dwg D3789

09/07/20 (15)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 809660

(15) 4

Work Order ID 48674

July 2, 2009 3:05:14 PM



Page 4

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Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

09/17/00 (10)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/21 HJ
MF 09-09-20

Picklist Print

July 2, 2009 3:05:14 PM

Page 1

Work Order ID: 48674

Parent Item: D3789-3RevA

Parent Item Name: Clamp


Comments:

Start Date: 07/02/2009

Required Date: 07/15/2009

Start Qty: 15.00

Required Qty: 15.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2611RevC		Manufactured	No			100	Each	31.0000	15.0000			
												
Bearing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	50581	31
----	-------	----

46841	31
-------	----

D2423RevB1		Manufactured	No			170	f	767.4300	1.1053			
												

Lug Extrusion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	767.43
----	--------

43722	219.5
-------	-------

44529	22.39
-------	-------

45800	525.54
-------	--------

43722

1.7187

15
09/07/20

mk 09/07/09

DART AEROSPACE LTD		Work Order: 48674
Description:		Part Number: 03789-3
Inspection Dwg:	Rev:	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	±.030	3.448	✓			
0.75	"	.751	✓			
0.38	"	.374	✓			
0.31	"	.308	✓			
0.40	"	.395	✓			
4.20	"	4.202	✓			
0.40	"	.400	✓			
1.19	"	1.190	✓			
1.12	"	1.127	✓			
0.56	.8	.565	✓			
2.07	"	2.073	✓			
2.63	"	2.630	✓			
Ø.811	+ .0005 - .0020	.8115	✓			
Ø.257	+ .006 - .001	.258	✓			
R.0.34	.3	.34	✓			
R.0.25	"	.25	✓			
R.0.032	"	.032	✓			
R.0.38	"	R.38	✓			
R.1.38	"	1.376	✓			
R.0.20	"	.200	✓			
R.0.06	"	.062	✓			
R.0.25	"	.250	✓			
R.0.50	.5	.500	✓			

Measured by: SS	Audited by: SL	Prototype Approval:	N/A
Date: 09/07/13	Date: 09/07/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

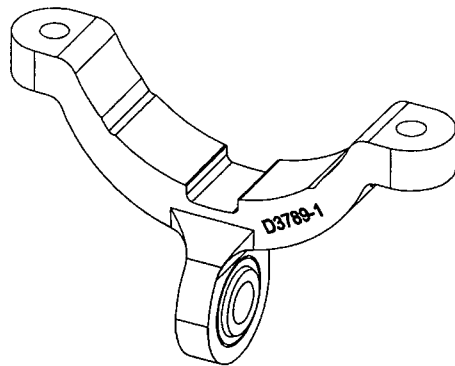
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

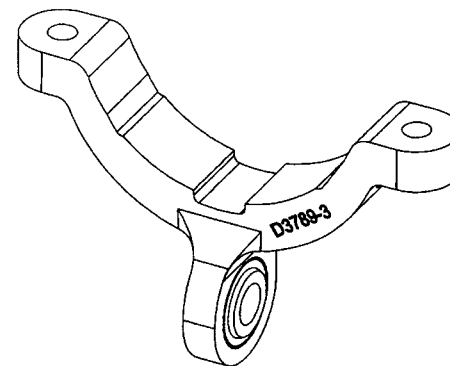
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

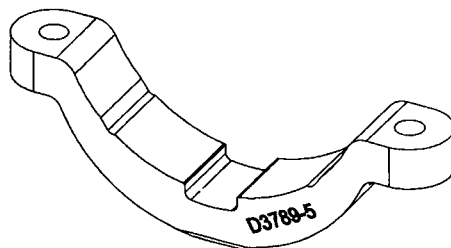
NOTE: Date & initial all entries



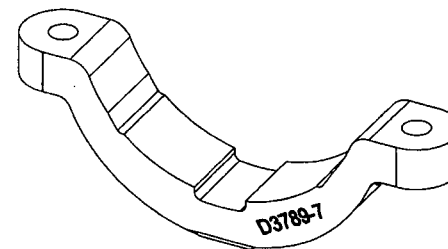
D3789-1 CLAMP



D3789-3 CLAMP



D3789-5 CLAMP



D3789-7 CLAMP

REFERENCE ONLY



DEO ATTACHED

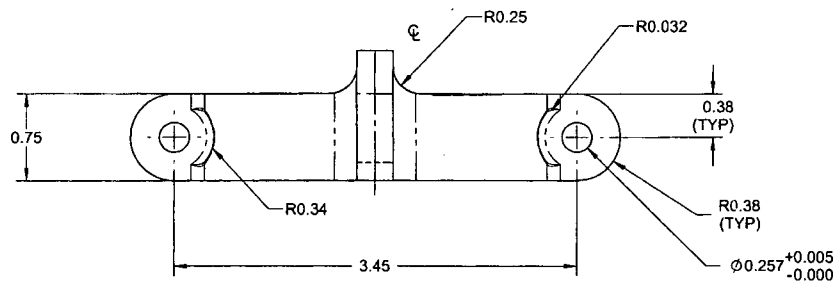
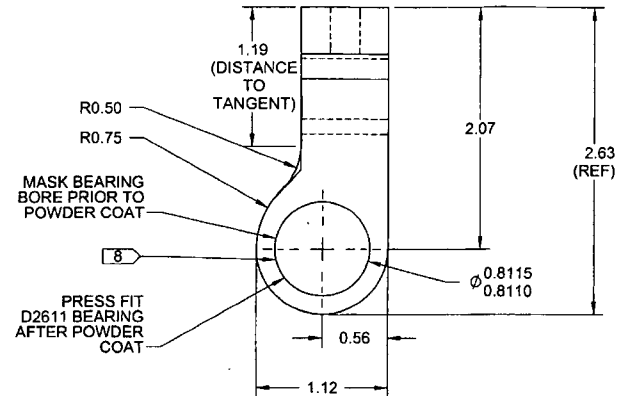
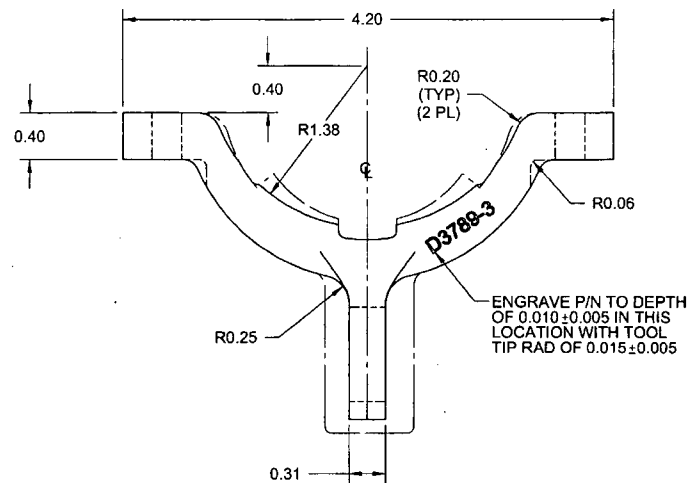
RELEASE
08/12/21

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs
D3789-3, 0.16 lbs
D3789-5, 0.14 lbs
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT ϕ

48674

A		NEW ISSUE		HS	08.05.21
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	HS				
CHECKED		DRAWING NO.	D3789	REV.	A
MFG. APPR.				SHEET 1 OF 5	
APPROVED		TITLE		SCALE	
DE APPR.		CLAMP		NTS	
DATE	08.05.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			







D3789-3 CLAMP

REFERENCE ONLY

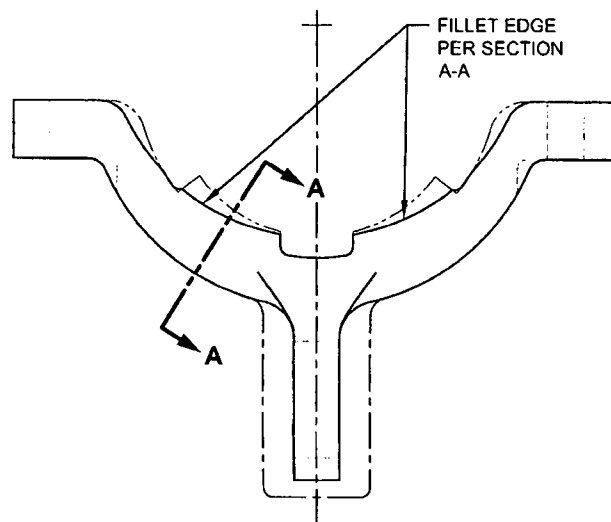
DEO ATTACHED

RELEASE

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3789	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	08.05.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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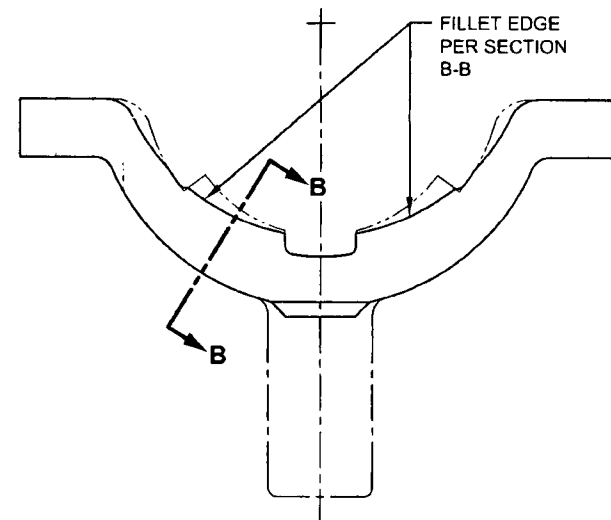
DRAWING NO. D3789	TITLE CLAMP	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3789-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED [Signature]	MFG. APPR. [Signature]	APPROVED [Signature]		DE APPR. [Signature]		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23		DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



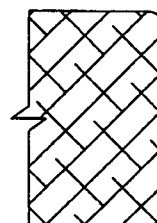
D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

REFERENCE ONLY

48674

RELEASED
09/05/04 [Signature]

SEE PAR 122 FOR FURTHER DETAILS

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